










Date: Wednesday, 8/15/2007 3:18:27 PM  
User: Jean-Luc Menard

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 33907		
Estimate Number	: 11001		
P.O. Number	: <u>N/A</u>	Part Number	: D26022
This Issue	: 8/15/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 31333	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 8/31/2007 Qty: 20 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM		

## Additional Product

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
			
<p>Comment: Qty.: 1.4146 sf(s)/Unit Total : 28.2912 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M105225</u></p> <p style="text-align: right;"><u>SAO 07/08/16</u></p>			
2.0	WATER JET	FLOW WATER JET	
			
<p>Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 &amp; -2 ***** Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u>  2-Deburr if necessary</p> <p style="text-align: right;"><u>SAO 07/08/16</u> 20</p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: right;"><u>SAO 07/08/16</u> 20</p>			
4.0	QC8	SECOND CHECK	
			
<p>Comment: SECOND CHECK</p> <p style="text-align: right;"><u>En 07/08/20</u> (420) <u>coankp</u></p>			

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/08/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/23	6.0	20 parts were sent to Alstria before Bending. R.C. QC Inspector (ED) inspected for Deburring and Placement the wrong stuff	<i>[Signature]</i>	have parts get Bent as per Dwg. D2602 - re-align and proceed @ sequence 7.0	SB 07/08/23 45	ED 07/08/23	<i>[Signature]</i>	<i>[Signature]</i>

NOTE: Date & initial all entries

## Process Sheet

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Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 33907

Part Number: D26022

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

100% 07/08/23 (20)

SB 07/08/29 (20)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-08-22

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57175

PC 7/8/31

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/31

Job Completion



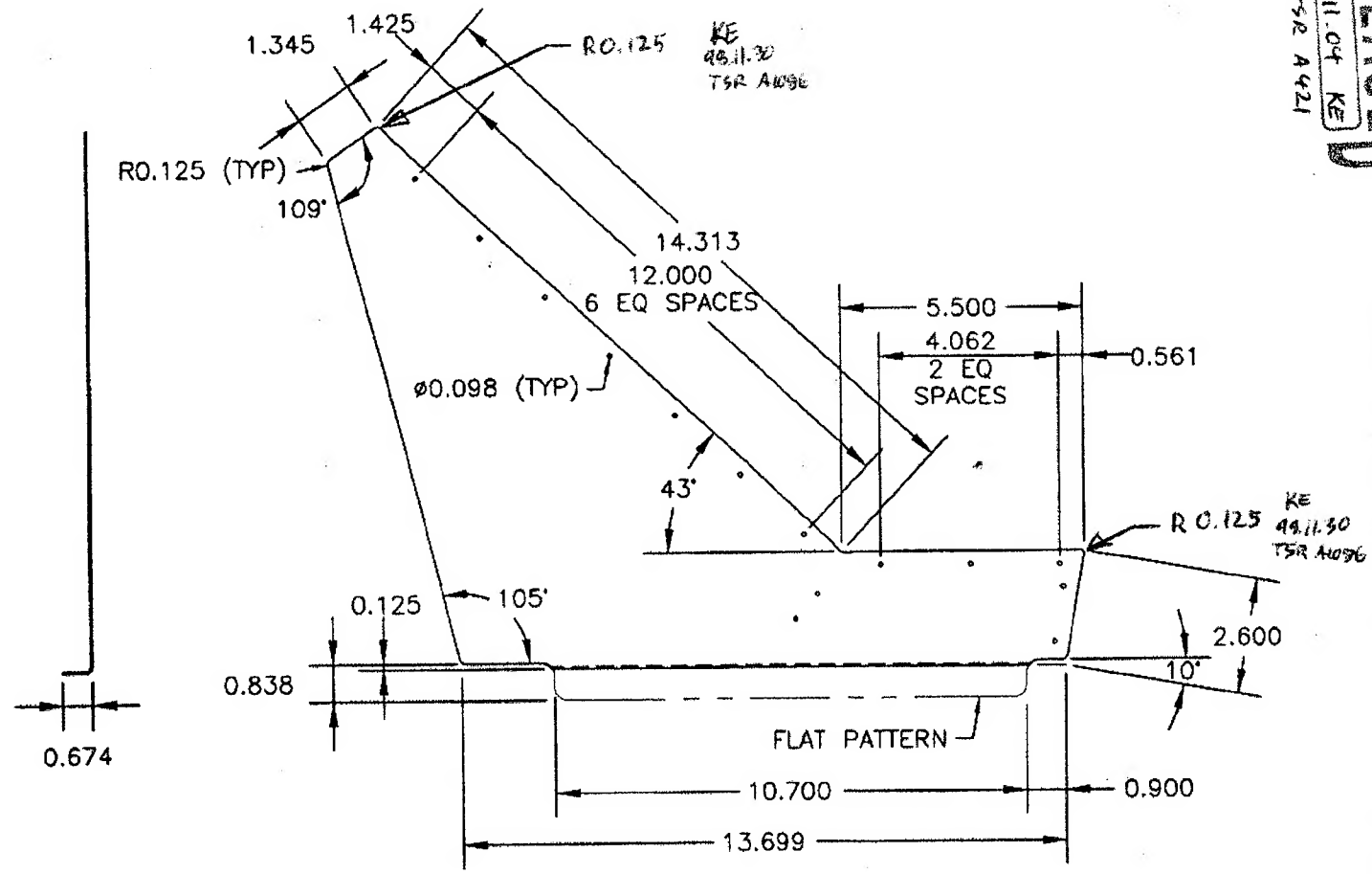
07.08.31

**DART**

QA COPY ISSUED

RELEASED  
97.11.04 KE  
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED KE	APPROVED B.W.	DRAWING NO. D2602
DATE 97.10.22	DATE 97.10.22	REV. A SHEET 1 OF 1
		SCALE 1:4
		TITLE CONSOLE SIDE
		REVISIONS D2602 WAS D206-547-21/-22
AI	02.06.04	ADD FINISH



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
 PROFILE CONTROLLED BY FOLIO H2602  
 BEND RADIUS 0.093  
 FINISH: CHEMICAL CONVERSION COAT PER PART QQ-A-250 4.1 **AI**  
 D2602-1 SHOWN  
 D2602-2 OPPOSITE

